

Date: Friday, 30/05/2008 10:13:11 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER FWD SADDLE
Job Number : 39604	
Estimate Number : 11079	
P.O. Number :	Part Number : D5953
This Issue : 30/05/2008 S.O. No. :	Drawing Number : D5953 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 39509	Material :
Written By :	Due Date : 15/06/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 08.5.30</u>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:f ecn 826 06.12.06 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 D6101-007(7075-T7351)
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
 Batch: B34371

25 08/06/06

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

28 08/06/06

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET

28 08/06/06

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

58 08/06/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

212/12 08/06/08 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:11 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 39604

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 107925



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:15
320 °F
1:45

M-L 08/06/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 08/06/09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(GX)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/4/9

369

9.0

QC21

FINAL INSPECTION W/O RELEASE



08/06/09

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



W 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39604
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.746		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.503	.503	.504		
N	1.615	1.635		1.630	1.625	1.625	1.625		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.384	1.385	1.385	1.384		
U	2.000	2.020		2.004	2.005	2.005	2.006		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ST</i>	Audited by: <i>SA</i>
Date: 08/06/06	Date: 08/06/06

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 391604
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

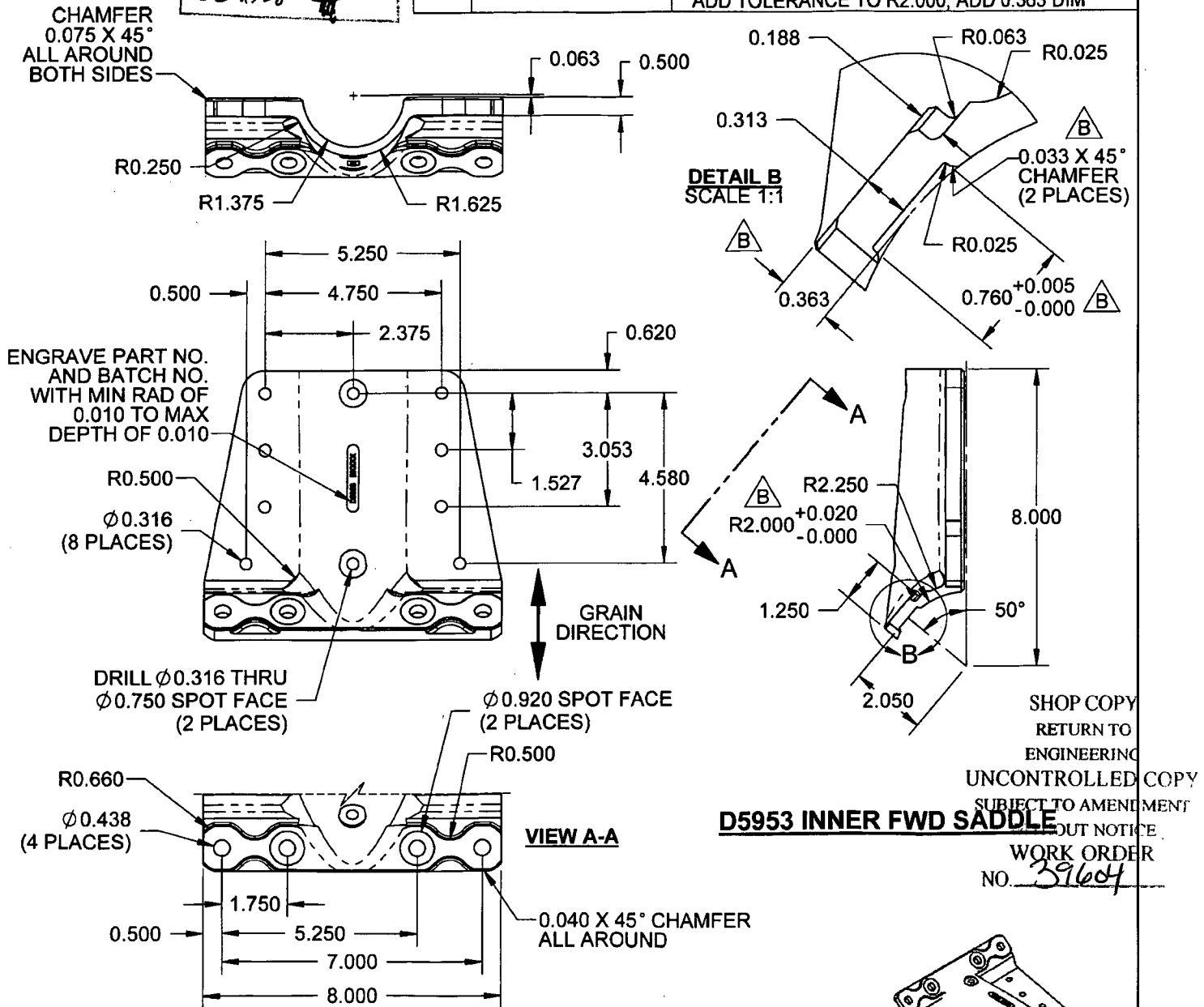
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.438	0.443		442	440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.210				
D	6.995	7.005		7.020	7.020				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.321	.318				
H	1.522	1.532		1.528	1.528				
I	3.048	3.058		3.051	3.051				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318		.318	.318				
L	0.495	0.505		.500	.520				
M	0.490	0.510		.505	.502				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		8.001	8.001				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.500	.500				
T	1.375	1.395		1.388	1.335				
U	2.000	2.020		2.010	2.005				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SS</i>	Audited by: <i>SS</i>
Date: 08/06/06	Date: 08/06/06

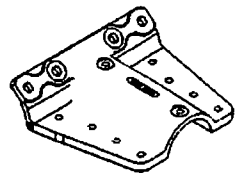
Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>DD</i>

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

